



Technical Bulletin

JOHNSON MANUFACTURING COMPANY
Princeton, Iowa 52768-0096

JOHNSON'S C-71-2 CORE BAKING FLUX CONCENTRATE Part No. 28-00 Series

DESCRIPTION:

Johnson's C-71-2 Core Baking Flux is proven reliable for oven baking of copper or fins to solder coated tubes in radiators and heat exchanger applications. The improved wetting agent in C-71-2 offers increased wettability yet does not remain behind to cause discoloration of the core. This flux vaporizes during the heating cycle leaving a good clean surface so radiators are ready for header dip soldering.

PHYSICAL DATA:

Specific Gravity	1.220 ± .005 @ 60° F (As Shipped)
	1.030 ± .005 @ 60° F (Diluted with 8 parts water)
pH	0-1
Appearance	Red Color, May Disappear During Use
Odor	Mild Organic Odor

USAGE:

C-71-2 Flux Concentrate should be diluted with eight (8) parts of clean water to one (1) part of flux making the specific gravity of mixed flux 1.030 ± .005 @ 60° F (4.2° Be'). Too high concentration of this flux can reduce solder flow, as can too low a concentration. Make any changes in dilution of the flux and water cautiously from the recommended mix.

Concentration of the flux solution is maintained by daily checking of the specific gravity with a hydrometer and the addition of the correct balance of make-up flux.

Before oven baking, the cores are usually completely submerged in the flux tank and then drained. Other means for applying the flux include waterfall or spraying.

This flux vaporizes at soldering temperatures, as the solder flows, leaving a good clean surface. Remember, this flux contains acid and remains corrosive until reaching soldering temperature which decomposes and vaporizes the flux. Any areas wetted with this flux must be heated to soldering temperatures and the vaporized flux vented to the atmosphere.



TO ORDER CALL (800) 747-0030, FOR SUPPORT CALL (563) 289-5123, TO SEND FAX (563) 289-3825, EMAIL TO johnsonmfg@aol.com

HANDLING:

Wear protective clothing and eye wear when handling this flux. Maintain proper ventilation and always read the *OSHA Material Safety Data Sheets* for all chemical products prior to use. Store, mix and use in non-metallic containers only.

WASTE DISPOSAL:

Since local laws vary, we cannot make specific recommendations.